






Date: Monday, 3/13/2006 7:28:16 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COLLECTIVE LOCK
Job Number : 26195	
Estimate Number : 11948	
P.O. Number : N/A	Part Number : D3372041
This Issue : 3/13/2006 S.O. No. : N/A	Drawing Number : D3372 REV B, D3369 Rev. A1, D3384 Rev. A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 25501	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 3/13/2006
Checked & Approved By : <u>06.03.13</u>	Qty: 3 D / 5 Um: Each
Comment : Est Rev:A Removed from 9 Digit 06-01-13 JLM	3/7 KA
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	D27287 Decal
	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2728-7 Decal <u>M15464</u>	
2.0	D33721 Main Body
	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3372-1 Main Body <u>B22281</u>	
3.0	D33725 Cam Lock Shaft
	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3372-5 Cam Lock Shaft <u>B22290</u>	
4.0	D33727 Slider Body
	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3372-7 Slider Body <u>B22291</u>	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 26195

Part Number: D3372041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	D33731	Cam Lock
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3373-1 Cam Lock

QTY 7 KA B23643 (Key C420A)

QTY 3 - D B22293

ml 06/03/13

6.0	AN542A	Bolt
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN5-42A Bolt

M16762

(10)

ml 06/03/13

7.0	516WC	SS Flat Washer 5/16
-----	-------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 5/16WC

SS Flat Washer

M19611

A/RN/ALocktite 262

M16507

(10)

8.0	D33841	Cyclic Sock
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3384-1

Cyclic Sock

B22340 (9)

D3384-043 (1) B23880

ml 06/03/13

9.0	CBL460	Loop Sleeve
-----	--------	-------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CBL-460

Loop Sleeve

M19476 (2ty 18)

ml 06/03/13

10.0	CBL1240	Cable
------	---------	-------



Comment: Qty.: 0.6999 f(s)/Unit Total : 3.4997 f(s)

Pick:

Qty Part Number Description Batch

8" CBL-1240 Cable

M16713

~~11.228 15"~~

ml 06/03/13

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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## Process Sheet

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Drawing Name: COLLECTIVE LOCK

Job Number: 26195

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

AN960416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960-416 Washer M5519

(20)

✓

12.0

HX81

1/4"-20 SHCS 3/8" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HX-81 1/4"-20 SHCS 3/8" long M16971

(10)

✓

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372

Identify as D3372-3

(10)

ml 06/03/13

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

(10)

06.03.13

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as D3369-5

(10)

ml 06/03/15

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack weld lock shaft as per Dwg D3372

Qty Part Number Description Batch

A/RN/A SS Rod

M19555

PD

06-03-15

(10)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 06/13/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COLLECTIVE LOCK

Job Number: 26195

Part Number: D3372041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

Qty Part Number Description Batch

A/R N/A Locktite 262

Identify as D3372-053

*make assey for D3372-041  
as per Dwg D3372*

2-Assemble D3372-051 as per Dwg D3372. Identify as D3372-051 and attach keys. Ensure that assembly locks and unlocks smoothly.

*mfo06/03/15*  
(10)

3-Assemble lanyard to cyclic sock as per Dwg D3384

4-Assemble D3384-043 to D3372-051 using 1/4"-20 socket head cap screw and washers as per Dwg D3371.

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06/03/16*  
10

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST069

Record Key #

~~5-177A~~ C420A x7  
1x C 177A  
1x C006A  
1x C078A

*C 06/03/20*

(10)

20.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/03/21*

Job Completion



*u 06-03-21*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

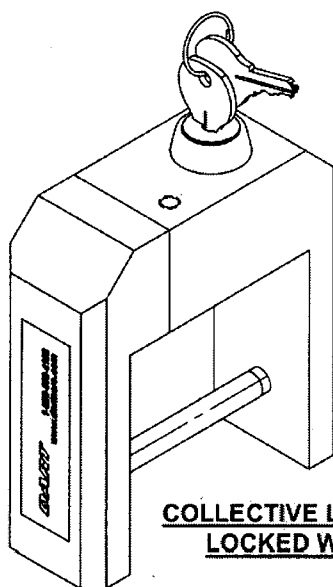
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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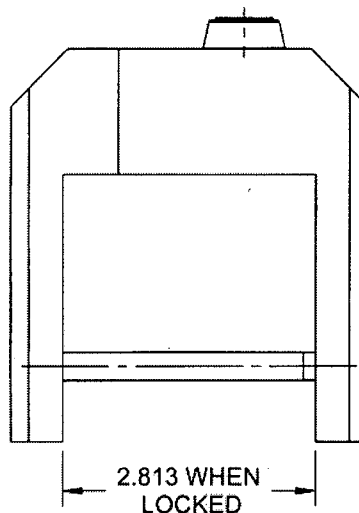




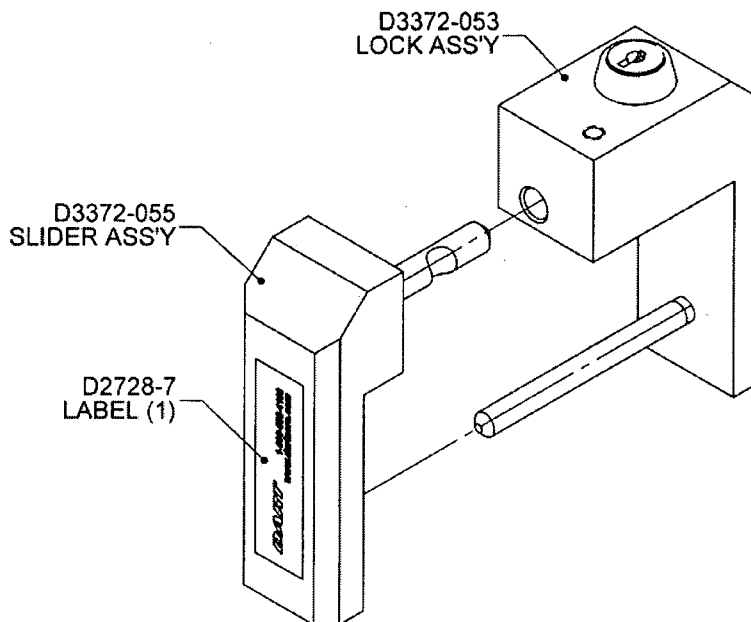
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3372</b>	REV. B SHEET 1 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN  
LOCKED WITH KEYS**



2.813 WHEN  
LOCKED



**D3372-051 AS350 COLLECTIVE LOCK ASS'Y**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
*[Signature]*  
05/04/28

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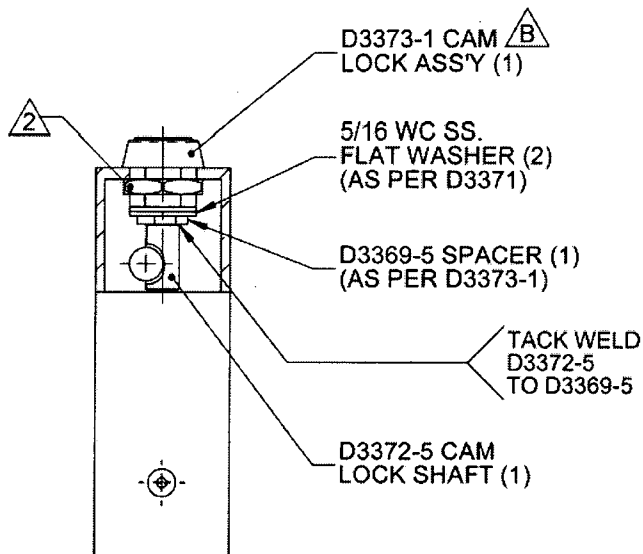
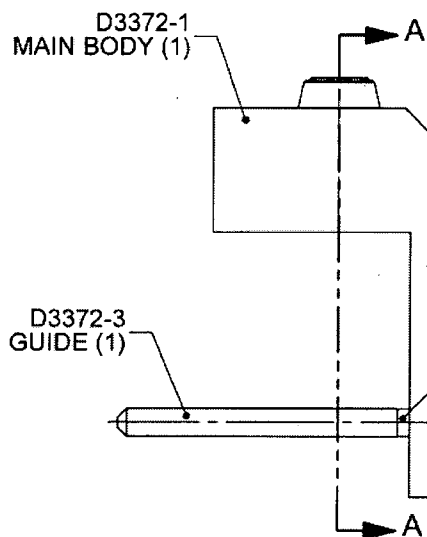
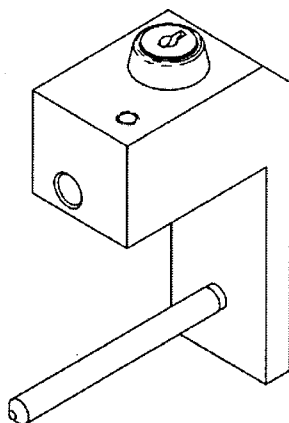
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DATE <b>05.02.23</b>	TITLE <b>COLLECTIVE LOCK</b>		SCALE 1:2

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[Signature]  
05/04/23



**SECTION A-A**

**D3372-053 LOCK ASS'Y**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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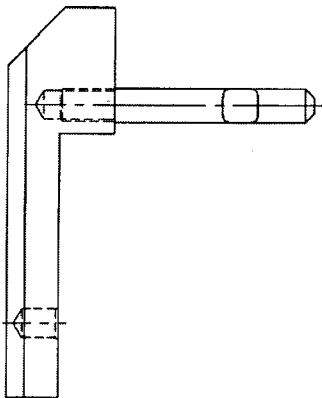
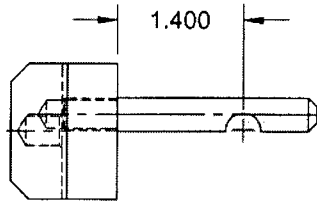
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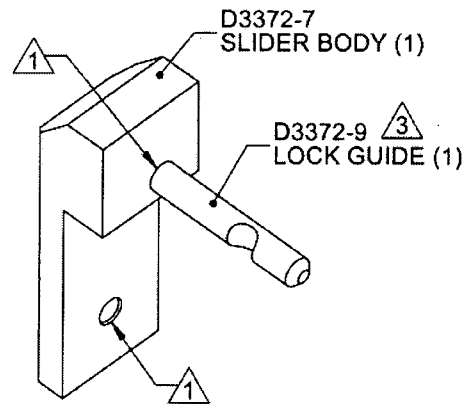




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DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2



RELEASED  
*[Signature]*  
05/04/23



### D3372-055 SLIDER ASS'Y

#### NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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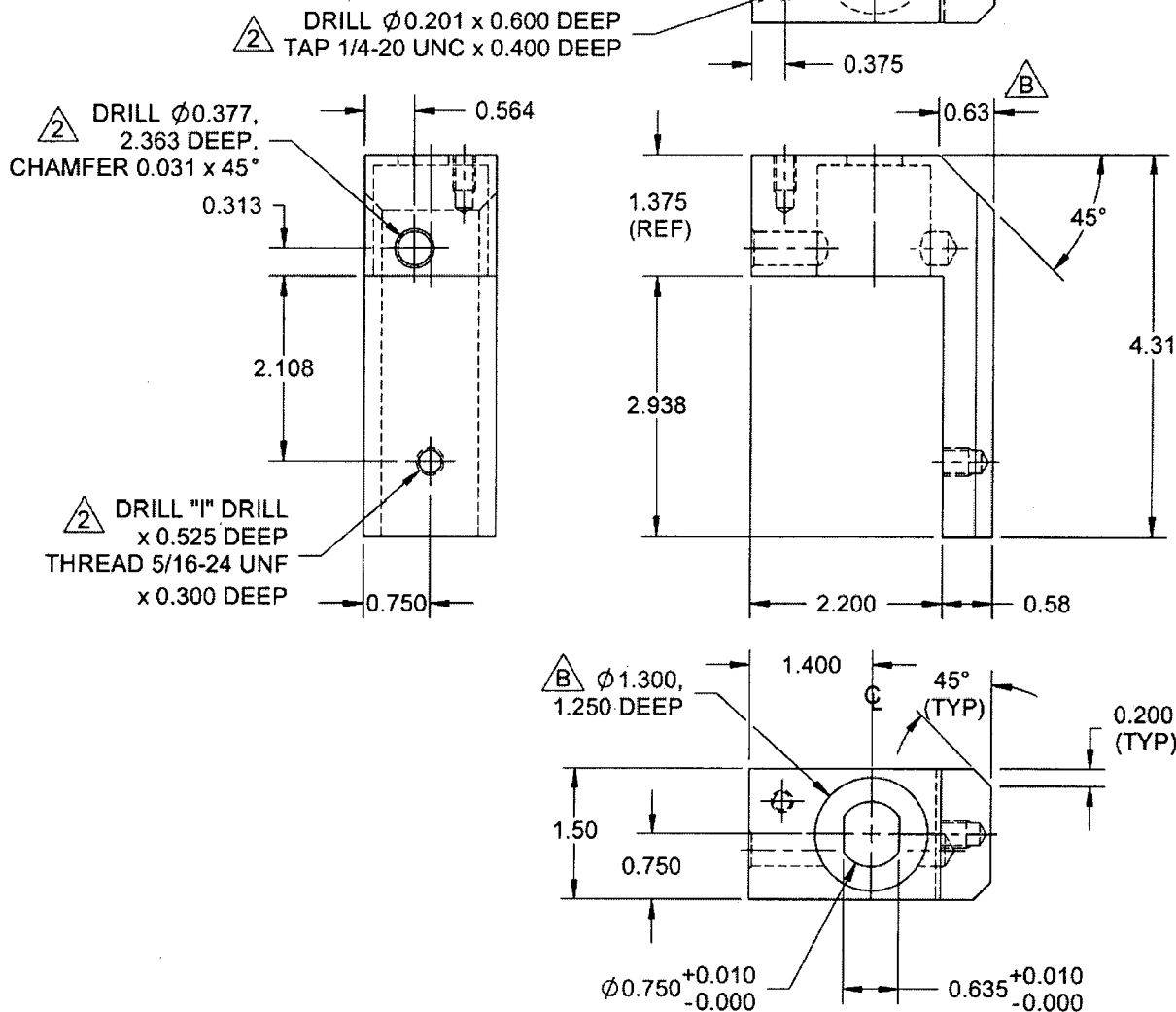
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DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2

RELEASED  
05/04/23



### D3372-1 MAIN BODY

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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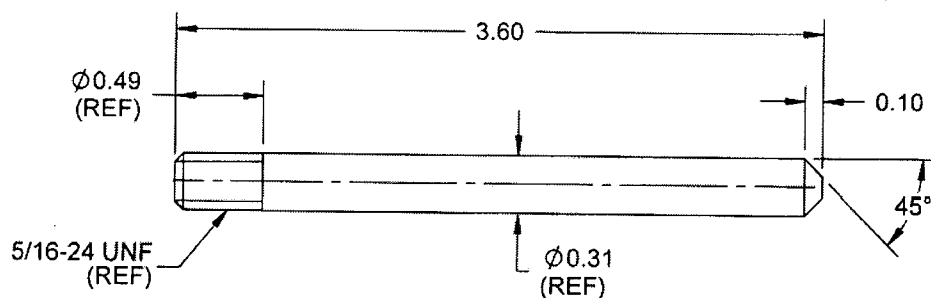




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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

## SPECIFICATION CONTROL DRAWING

RELEASED  
*[Signature]*  
05/04/23



### D3372-3 GUIDE

#### NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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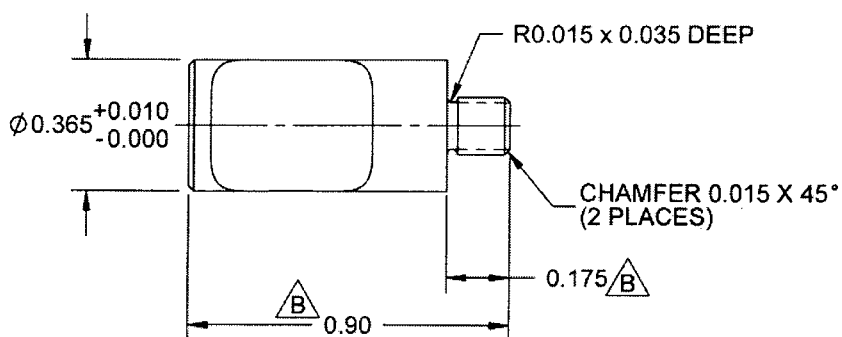
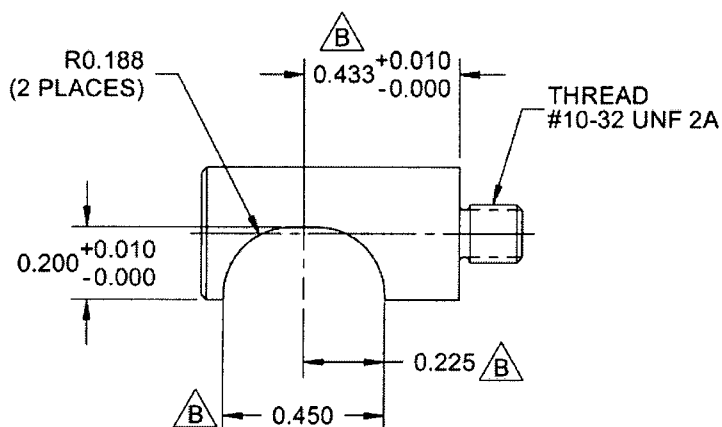
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

RELEASED  
*[Signature]*  
05/04/28



### D3372-5 CAM LOCK SHAFT

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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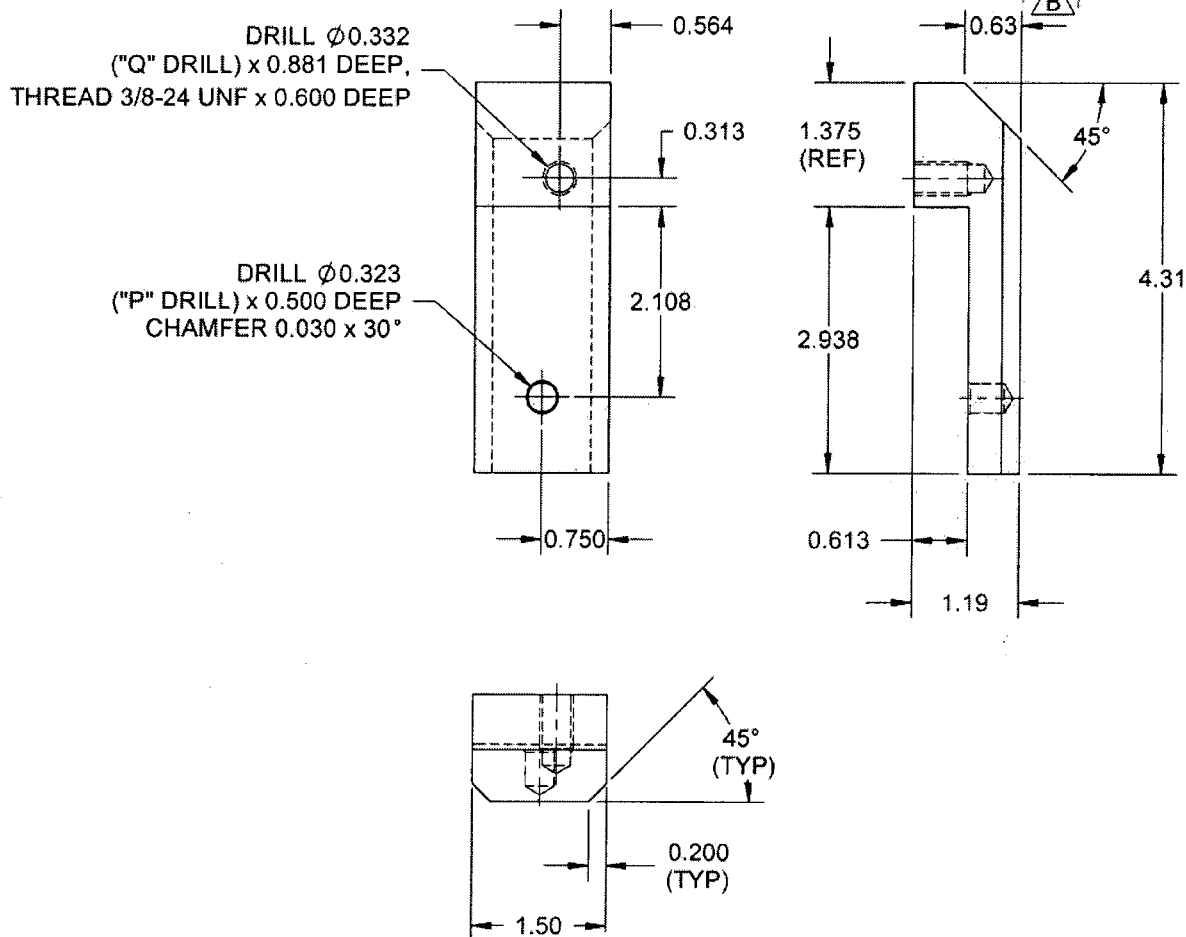
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DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2



### D3372-7 SLIDER BODY

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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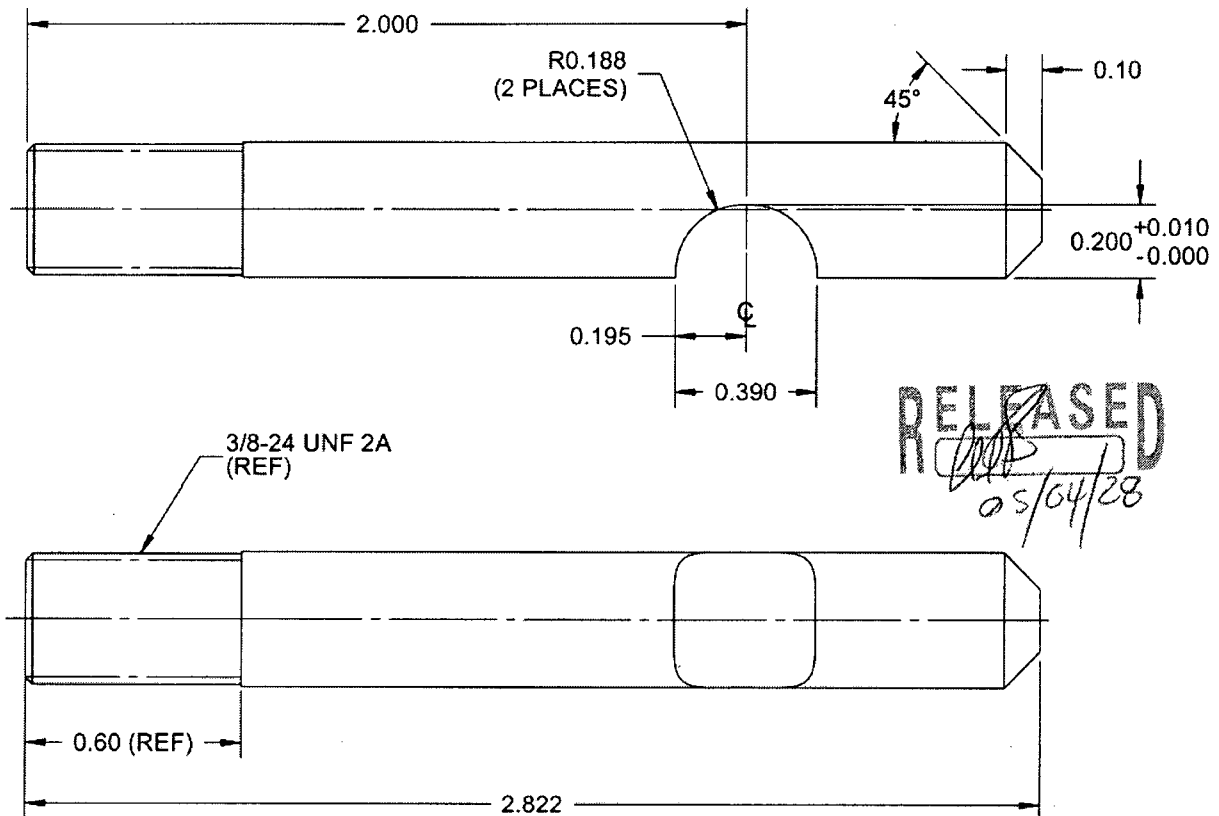
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

## SPECIFICATION CONTROL DRAWING



### D3372-9 LOCK GUIDE

#### NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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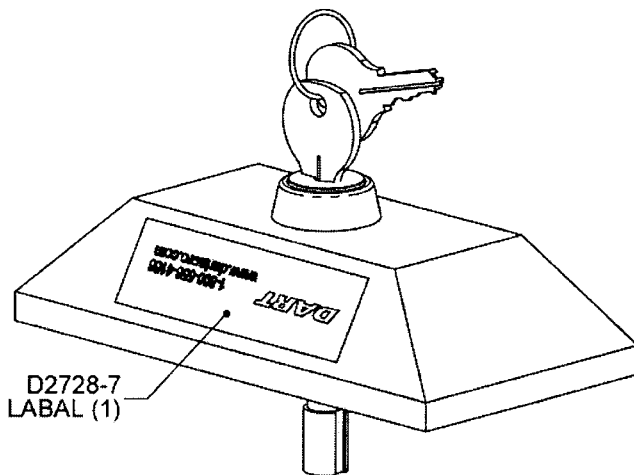




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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 1 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 1:1.5
A	04.12.16	NEW ISSUE	

ADD TACK WELD  
0.865 WAS 0.925

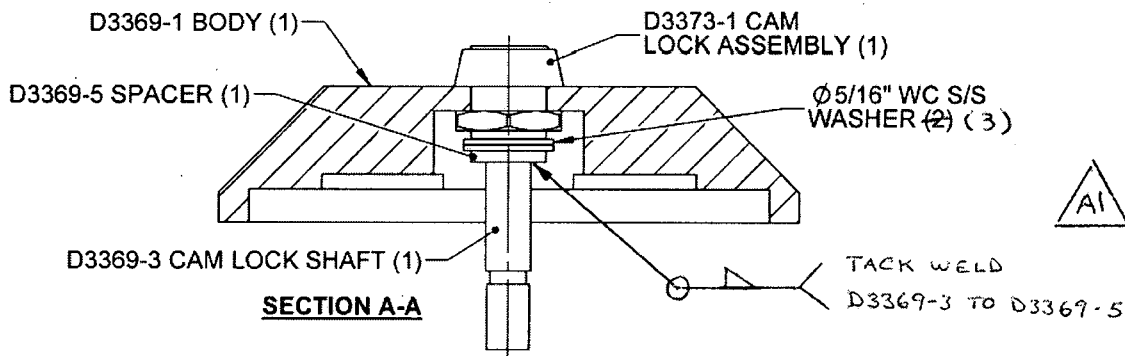
AI ~~MD~~ 05.02.11



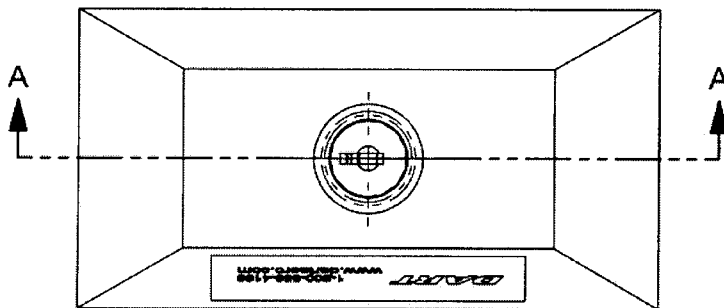
D2728-7  
LABAL (1)

**BATTERY LOCK SHOWN LOCKED WITH KEY**

RELEASED  
*[Signature]*  
05/02/11



**SECTION A-A**



**D3369-041 BATTERY LOCK ASSEMBLY**

**NOTES:**

- 1) WELD PER DART QSI 004

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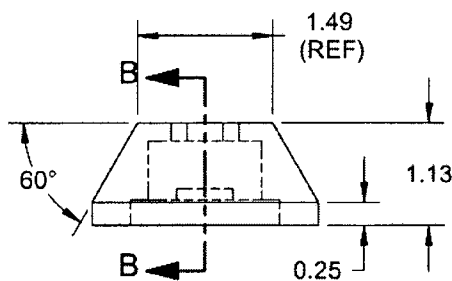
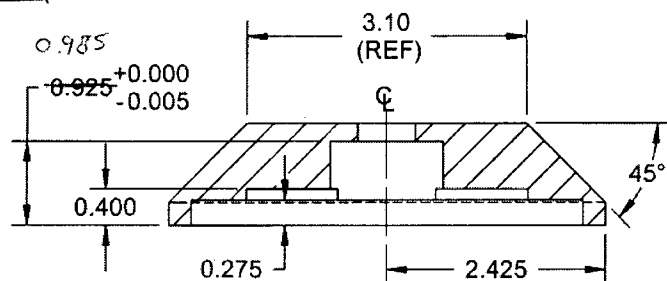
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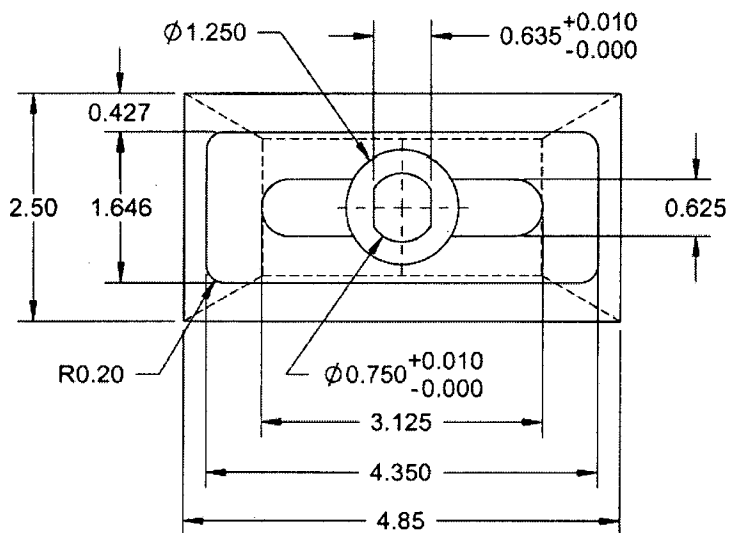




DESIGN 43	DRAWN BY 43	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 04.12.16		TITLE BATTERY LOCK	SCALE 1:2



**SECTION B-B**



RELEASED  
05/02/11

**D3369-1 BODY**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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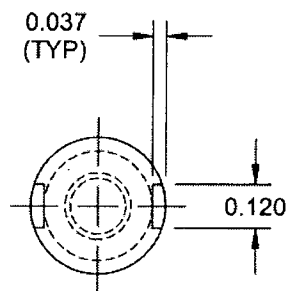
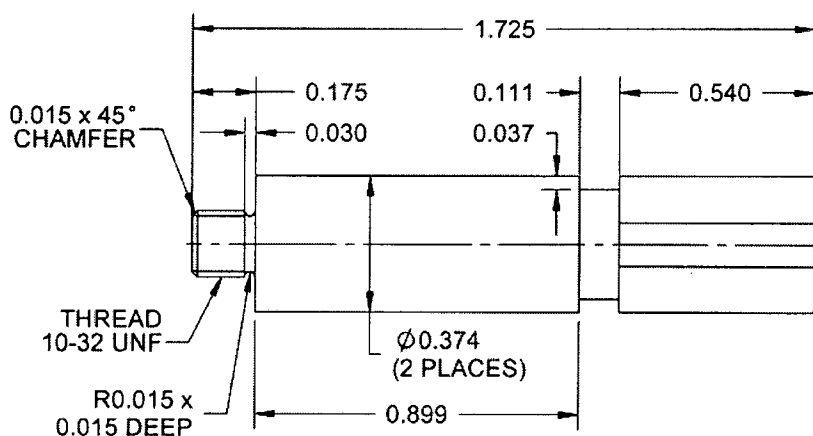
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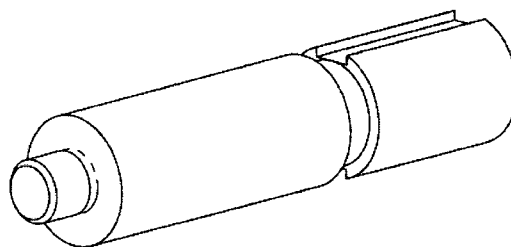




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DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1



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85/02/11



### D3369-3 CAM LOCK SHAFT

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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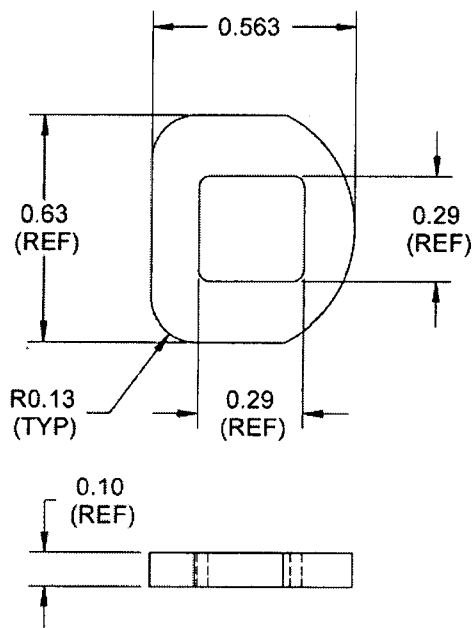
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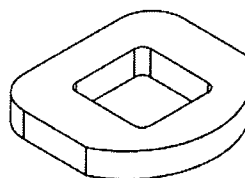
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DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

## SPECIFICATION CONTROL DRAWING



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*[Signature]*

05/02/11



-5  
**D3369 SPACER**



### NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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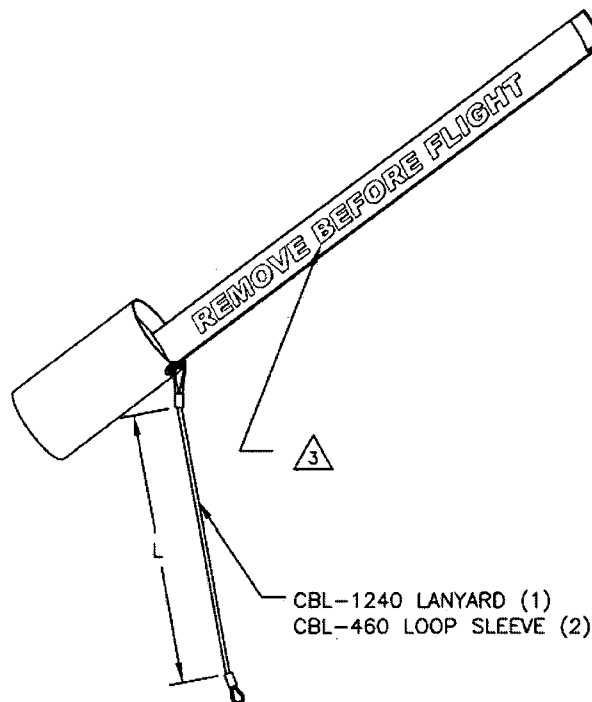
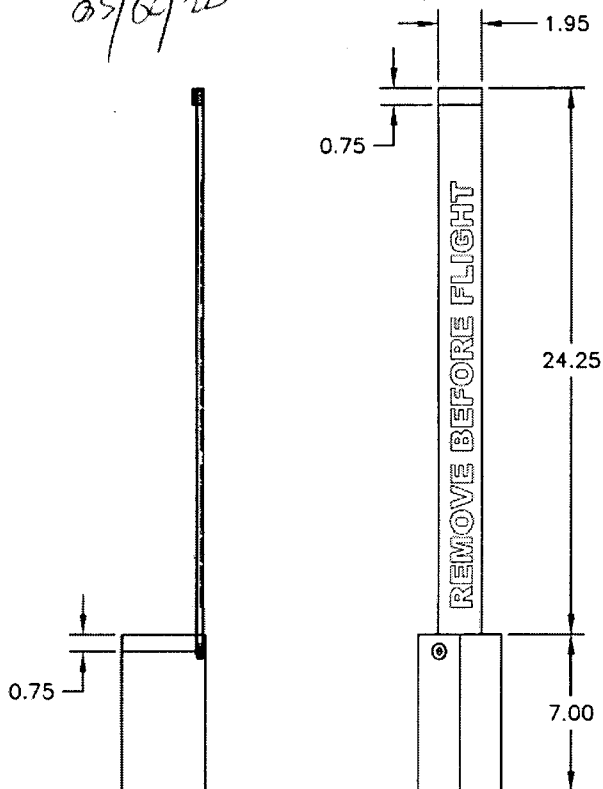




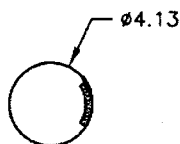
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3384	REV. A SHEET 1 OF 1
DATE 05.01.20	TITLE SOCK ASSEMBLY		SCALE NTS
A	05.01.20	NEW ISSUE	
A1	05.04.19	ADDED D3384-049	

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05/02/22



**D3384-OXX**



**D3384-1 SOCK**

P/N D3384-OXX	L (in)
D3384-041	24
D3384-043	8
D3384-045	20
D3384-047	28
D3384-049	30

**NOTES:**

- 1) POSSIBLE SUPPLIER: TULMAR
- 2) THREAD: STITCHING IAW D-6193 6 TO 10 STITCHES PER INCH
- 3) STENCIL THE FOLLOWING: REMOVE BEFORE FLIGHT ON BOTH SIDES OF STRIP WITH SUBJECT LETTERS
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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